

PATENT ABSTRACTS OF JAPAN

(11)Publication number : 06-210370

(43)Date of publication of application : 02.08.1994

(51)Int.Cl.

B21D 37/20

B21D 37/18

(21)Application number : 05-006642

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(22)Date of filing : 19.01.1993

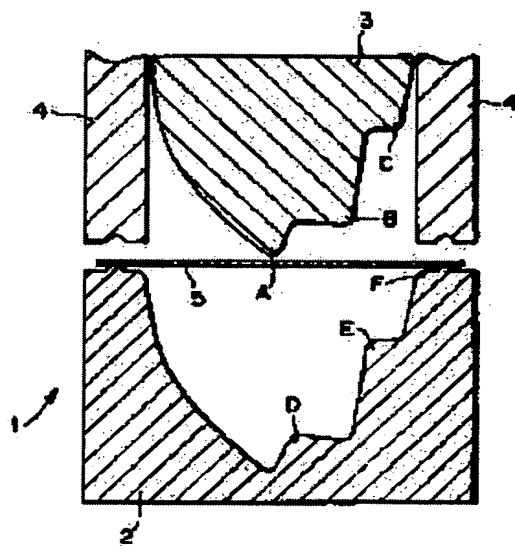
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(54) METALLIC DIE FOR PRESS FORMING

(57)Abstract:

PURPOSE: To prevent the generation of forming defects by forming recessed parts with a specific average diameter and average depth on the surface of a metallic die and specifying the average intervals of the recessed parts.

CONSTITUTION: At the time of forming the press material 5 for a metallic die 1, plural recessed parts are formed on a part or all of the surface that is in contact with the press material 5. The average diameter of the recessed part is formed to be $30\mu\text{m}$ – $100\mu\text{m}$, and the average depth $1\mu\text{m}$ – $10\mu\text{m}$ respectively. Simultaneously, the average space of the plural recessed parts is formed to be 1.3 to 3 times as large as the average diameter. The press material 5 is a thin sheet for automobiles having the surface roughness SRa of $\geq 1\mu\text{m}$. Thus, a lubricating oil is sealed in the recessed parts, and sliding property between the press material and the metallic die is improved.



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[Date of request for examination]

[Date of sending the examiner's decision of rejection]

[Kind of final disposal of application other than the
examiner's decision of rejection or application
converted registration]

[Date of final disposal for application]

[Patent number]

[Date of registration]

[Number of appeal against examiner's decision of
rejection][Date of requesting appeal against examiner's decision
of rejection]

[Date of extinction of right]

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